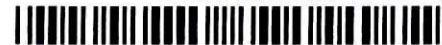




Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2574
Job Sheet 173726



Part No: D2574

Job Qty: ~~12~~ ea **DAS**
10 21 9-89

Part Name: Saddle, Aft, In



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/6/18

Job Tracking No:

Due Date: 3/30/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV F IPP Rev: I As Per RevE 06-01-27 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea		3/29/18	0.00	0.00	Start Up Machining		SBL 18/04/20
100	CNC Vertical Machining	12 pcs		3/29/18	1.21	18.75	HAAS 1		SBL 18/04/20
110	Mill Conv	12 pcs		3/29/18	0.00	1.50	Mill Conv 1		SBL 18/04/20
120	QC	12 pcs		3/29/18	0.00	0.00	QC2		SBL 18/04/20
130	QC	12 pcs		3/29/18	0.00	0.00	QC8		mm 18/04/23
140	HandFinish	12 pcs		3/29/18	0.00	0.48	HandFinish1		SA 18-04-24
150	Powdercoat	12 pcs		3/30/18	0.00	0.39	Powdercoat1		OK 18-04-24
160	QC	12 pcs		3/30/18	0.00	0.00	QC3		11-04-24
170	Packaging	12 pcs		3/30/18	0.00	0.00	Packaging3	51397	APR 25 2018
180	QC21-SA	12 Ea		3/30/18	0.00	0.00	QC21		3-89

Part Op 100 - Program Batch No. _____ 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
Descriptions: 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
110 - Machine keyway as per dwg D2573 & D2574
150 - START TIME: 12.00 FINISH TIME: 12.30.00 T: 300° M138760

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-005	Saddle Billet	12 Ea (1 ea)	90-Start up Operation	
(9x 5038651 -> 01x 5059502)				

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-005	12	29	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Aft Inboard	0.438Inches + 0.005 - 0.000	0.443 0.438		
2	Saddle, Aft Inboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
3	Saddle, Aft Inboard	3.495Inches + 0.010 - 0.000	3.505 3.495		
4	Saddle, Aft Inboard	1.745Inches + 0.010 - 0.000	1.755 1.745		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval																	
Description Work Order Deviation		Disposition		Completed By																	
				Lead hand / Supervisor Approval Verification																	
				QC / QA Coordinator Approval																	

Dart Aerospace Ltd.
1278 Aberdeen Street
Chatham, ON K6A 1K7
TEL: 1-813-632-6200
Email: sales@dartaero.com
www.dartaerospace.com



Container No: S061545

Part: D2574

Job No: 173726

Serial No/Batch: S061545

Revision: Rev.F

Inspector:

Date: 04/17/18

FAULT CATEGORY

Defect	☐ Power Loss/Surge	☐ Positioned Wrong
	☐ Folio/Program	☐ Outside Dimensions
	☐ Grain	☐ Over/Under tolerance
	☐ Weld	☐ Part Incorrect
	☐ Wrong Stock Pulled	☐ Part Lost/Missing
Delete/Unqualified	☐ Out of Sequence	☐ Part Moved
	☐ Off-set	☐ Drawing
	☐ Misabeled	☐ Finish
	☐ Fit/Function	☐ Misread
	☐ Misaligned/off center	☐ Turning Sequence

5	Saddle, Aft Inboard	7.990Inches	+ 0.020 - 0.000	8.010 7.990
6	Saddle, Aft Inboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
7	Saddle, Aft Inboard	0.257Inches	+ 0.005 - 0.000	0.262 0.257
8	Saddle, Aft Inboard	0.375Inches	+ 0.005 - 0.000	0.380 0.375
9	Saddle, Aft Inboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
10	Saddle, Aft Inboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
11	Saddle, Aft Inboard	0.558Inches	+ 0.020 - 0.000	0.578 0.558
12	Saddle, Aft Inboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
13	Saddle, Aft Inboard	1.365Inches	+ 0.010 - 0.000	1.375 1.365
14	Saddle, Aft Inboard	2.495Inches	+ 0.010 - 0.000	2.505 2.495
15	Saddle, Aft Inboard	4.119Inches	+ 0.010 - 0.000	4.129 4.119
16	Saddle, Aft Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
17	Saddle, Aft Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
18	Saddle, Aft Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
19	Saddle, Aft Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
20	Saddle, Aft Inboard	0.178Inches	+ 0.020 - 0.000	0.198 0.178
21	Saddle, Aft Inboard	3.210Inches	+ 0.040 - 0.000	3.250 3.210
22	Saddle, Aft Inboard	0.230Inches	+ 0.020 - 0.000	0.250 0.230
23	Saddle, Aft Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
24	Saddle, Aft Inboard	0.307Inches	+ 0.005 - 0.000	0.312 0.307
25	Saddle, Aft Inboard	0.760Inches	+ 0.005 - 0.000	0.765 0.760
26	Saddle, Aft Inboard	0.352Inches	+ 0.020 - 0.000	0.372 0.352
27	Saddle, Aft Inboard	0.470Inches	+ 0.060 - 0.000	0.530 0.470
28	Saddle, Aft Inboard	0.615Inches	+ 0.020 - 0.000	0.635 0.615
29	Saddle, Aft Inboard	0.053Inches	+ 0.020 - 0.000	0.073 0.053
30	Saddle, Aft Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
31	Saddle, Aft Inboard	1.500Inches	+ 0.020 - 0.000	1.520 1.500
32	Saddle, Aft Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
33	Saddle, Aft Inboard	0.240Inches	+ 0.040 - 0.000	0.280 0.240
34	Saddle, Aft Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
35	Saddle, Aft Inboard	2.000Inches	+ 0.020 - 0.000	2.020 2.000
36	Saddle, Aft Inboard	0.023Inches	+ 0.020 - 0.000	0.043 0.023

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

DART AEROSPACE LTD	Work Order: 173726
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.002	8.002	8.002	8.002		
F	0.490	0.510		0.502	0.502	0.498	0.498		
G	0.257	0.262		0.257	0.257	0.257	0.257		
H	0.375	0.380		0.375	0.375	0.375	0.375		
I	0.490	0.510		0.500	0.499	0.500	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.568	0.569	0.569	0.570		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.121	4.121	4.121	4.121		
P	0.115	0.135		0.135	0.127	0.127	0.127		
Q	0.115	0.135		0.130	0.130	0.130	0.130		
R	0.240	0.260		0.251	0.254	0.254	0.253		
S	0.115	0.135		0.125	0.125	0.125	0.124		
T	0.178	0.198		R0.188	R0.188	R0.188	R0.188		
U	3.210	3.250		3.232	3.232	3.232	3.232		
V	0.230	0.250		0.238	0.238	0.238	0.238		
W	0.115	0.135		0.125	0.125	0.125	0.125		
X	0.307	0.312		0.311	0.311	0.311	0.311		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.363	0.368	0.364	0.365		
AA	0.470	0.530		R0.500	R0.500	R0.500	R0.500		
AB	0.615	0.635		0.623	0.626	0.624	0.625		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.248	0.248	0.248	0.248		
AE	1.500	1.520		R1.500	R1.500	R1.500	R1.500		
AF	0.115	0.135		0.125	0.125	0.125	0.125		
AG	0.240	0.280		0.250	0.250	0.250	0.250		
AH	0.240	0.260		0.252	0.252	0.253	0.250		
AI	2.000	2.020		R2.000	R2.000	R2.000	R2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: SBL
Date: 18/04/19

Audited by: [Signature]
Date: 18/04/19

Rev	Date	Change	Revised by	Approved
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 173726
Description: Saddle, Aft Inboard		Part Number: D2574
Inspection Dwg: D2574 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5	6	7	8	By	Date
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.002	8.002	8.001		
F	0.490	0.510		.500	.500	.500	.500		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.500	.499	.499	.500		
J	1.174	1.184		1.174	1.174	1.174	1.174		
K	0.558	0.578		.568	.568	.568	.468		
L	1.174	1.184		1.174	1.174	1.174	1.174		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.130	.130	.133	.133		
Q	0.115	0.135		.253	.125	.124	.124		
R	0.240	0.260		.125	.252	.253	.252		
S	0.115	0.135		.128	.130	.126	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.241	.241	.241	.240		
W	0.115	0.135		.125	.125	.125	.123		
X	0.307	0.312		.311	.311	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.365	.365	.365	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.624	.624	.624	.625		
AC	0.053	0.073		.068	.070	.067	.065		
AD	0.240	0.260		.251	.251	.251	.251		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		.127	.130	.125	.125		
AG	0.240	0.280		.250	.250	.250	.250		
AH	0.240	0.260		.252	.252	.251	.251		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: SBC
Date: 18/04/14

Audited by: [Signature]
Date: 18/04/14

Rev	Date	Change	Revised by	Approved
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 173726
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	9 ¹	10 ²	3	4	By	Date
A	0.438	0.443		.438	.438				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.002	8.002				
F	0.490	0.510		.500	.500				
G	0.257	0.262		.257	.257				
H	0.375	0.380		.375	.375				
I	0.490	0.510		.500	.500				
J	1.174	1.184		1.174	1.174				
K	0.558	0.578		.568	.568				
L	1.174	1.184		1.174	1.174				
M	1.365	1.375		1.370	1.370				
N	2.495	2.505		2.500	2.500				
O	4.119	4.129		4.124	4.124				
P	0.115	0.135		.130	.133				
Q	0.115	0.135		.124	.125				
R	0.240	0.260		.251	.252				
S	0.115	0.135		.127	.127				
T	0.178	0.198		.188	.188				
U	3.210	3.250		3.230	3.230				
V	0.230	0.250		.241	.241				
W	0.115	0.135		.125	.124				
X	0.307	0.312		.311	.311				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.364	.364				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.624	.624				
AC	0.053	0.073		.070	.065				
AD	0.240	0.260		.252	.251				
AE	1.500	1.520		1.510	1.510				
AF	0.115	0.135		.130	.130				
AG	0.240	0.280		.250	.250				
AH	0.240	0.260		.252	.250				
AI	2.000	2.020		2.000	2.000				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

Measured by: SBL
Date: 18/04/20

Audited by: [Signature]
Date: 18/04/23

Rev	Date	Change	Revised by	Approved
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	